

Work Order ID 142188

March 02, 2016 8:58:02 AM

142188

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Item ID: D3595-200-300 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rubber Cushion 2.00" wide x 3.00" Long
 Start Date: 3/2/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 3/2/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: SA Date: 20160302 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3595	Rev A

100	FLOW WATER JET	0.00							
100									
Waterjet									
FLOW CNC Waterjet	Memo	0.01							
	1-Cut as per Dwg D3595 Dwg Rev: _____ Prog Rev: _____ 2-								
	Debur if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

cut by hand. SA
20160302
 20 FF MAR 02 2016
 20 DAS 38 9-88 MAR 02 2016
 20 DAS 38 9-88 MAR 02 2016

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Item ID: D3595-200-300

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rubber Cushion 2.00" wide x 3.00" Long

Start Date: 3/2/2016 Start Qty: 20.00

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Cust Item ID:

Required Date: 3/2/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St 416</u>	0.00							
130						<u>20</u>	<u>DAS</u>		
Packaging	Memo	0.00					<u>6</u>		
Packaging							<u>9-89</u>		MAR 03 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03				<u>MCS</u>			MAR 02 2016
Quality Control									
						<u>MCS</u>			MAR 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 142188

142188

Parent Item: D3595-200-300

D3595-200-300

Parent Item Name: Rubber Cushion 2.00" wide x 3.00" Long

Start Date: 3/2/2016

Required Date: 3/2/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 08-05-14 DD Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO80S.125		Purchased	No			110	sf	439.6530	0.0206	0.412			
MNEO80S 125										**	FF	MAR 02 2016	
NEOPRENE SHEET 0.125													

Location

Loc Qty

Loc Code

MAT052

439.653

94539

439.653

0.412

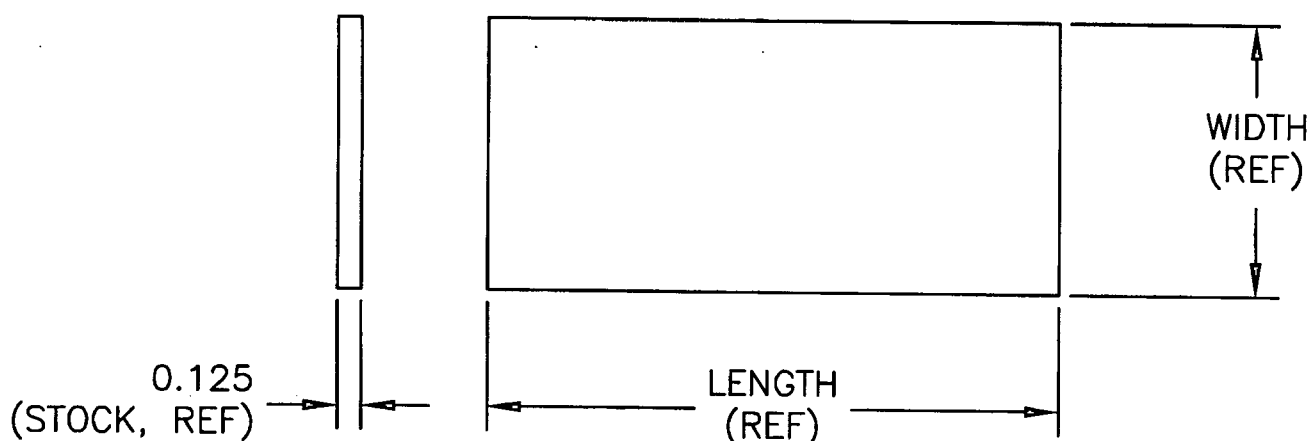


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3595	REV. A SHEET 1 OF 1
DATE 07.02.07		TITLE RUBBER CUSHION	SCALE NTS
A	07.02.07	NEW ISSUE	

RELEASED

07.02.14 *[Signature]*

SPECIFICATION CONTROL DRAWING



SPECIFICATION: D3595-XXX-YYY RUBBER CUSHION

WIDTH
LENGTH

EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

20160302

st

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK, *142/88*
80 DUROMETER (REF DART SPEC. M-NEO80-S.125)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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